

Date: Wednesday, 9/20/2006 3:23:20 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT X-TUBE EXT HEIGHT(-013)  
 Job Number : 28663  
 Estimate Number : 10563  
 P.O. Number : N/A Part Number : D205596107  
 This Issue : 9/20/2006 S.O. No. : NA Drawing Number : D205596107  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A  
 Previous Run : 28596 Material : N/A  
 Due Date : 10/10/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: D 05.03.21 Added bending procedure KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile &amp; type labels per PPP D205-596-107CHG001

KT 06-09-21 ①

2.0 D2890 Aft Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

B28490A DP 6-10-6

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DP 6-10-6

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions. Conformity check and sign off by engineering.

See attached

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

DP 6-10-6

2-Deburr &amp; Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

DP 6-10-6 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: S Date: 06/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.10.05	5	Half span on one side is 52.25" instead of 52.5"	CP 06.10.05 pv QSI 042	PART IS OK	DP 6.10.6	<u>[Signature]</u> 06.10.05	CP 06.10.05 pv QSI 042	<u>[Signature]</u> 06.10.05

NOTE: Date & initial all entries

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Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 28663

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

FC  
a.m.

06/10/12 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10-13 (1)

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime Start Finish  
Paint

1-Prime inside and outside with Immron per QSI 005 4.2

MT

06-10-16

(1)

9.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Job 10-17 (1)

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.6810 f(s)/Unit Total: 1.6810 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(10.09") Abrasion Strip

B24328

IT

06-10-19

11.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support

B25594

RT 06-10-19

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-28

Clamp

M101684

IT 06-10-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *S*   Date: 06/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 9/20/2006 3:23:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 28663

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

25 06-10-190

A/R Sikaflex -291

Expiry date:

N/A for this w/o 06-10-19

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-10-19 (1)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location:

PPP Rev: C

Rec'd 4/10/23 (1)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/23 (1)

Job Completion



C Lde 11/01/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

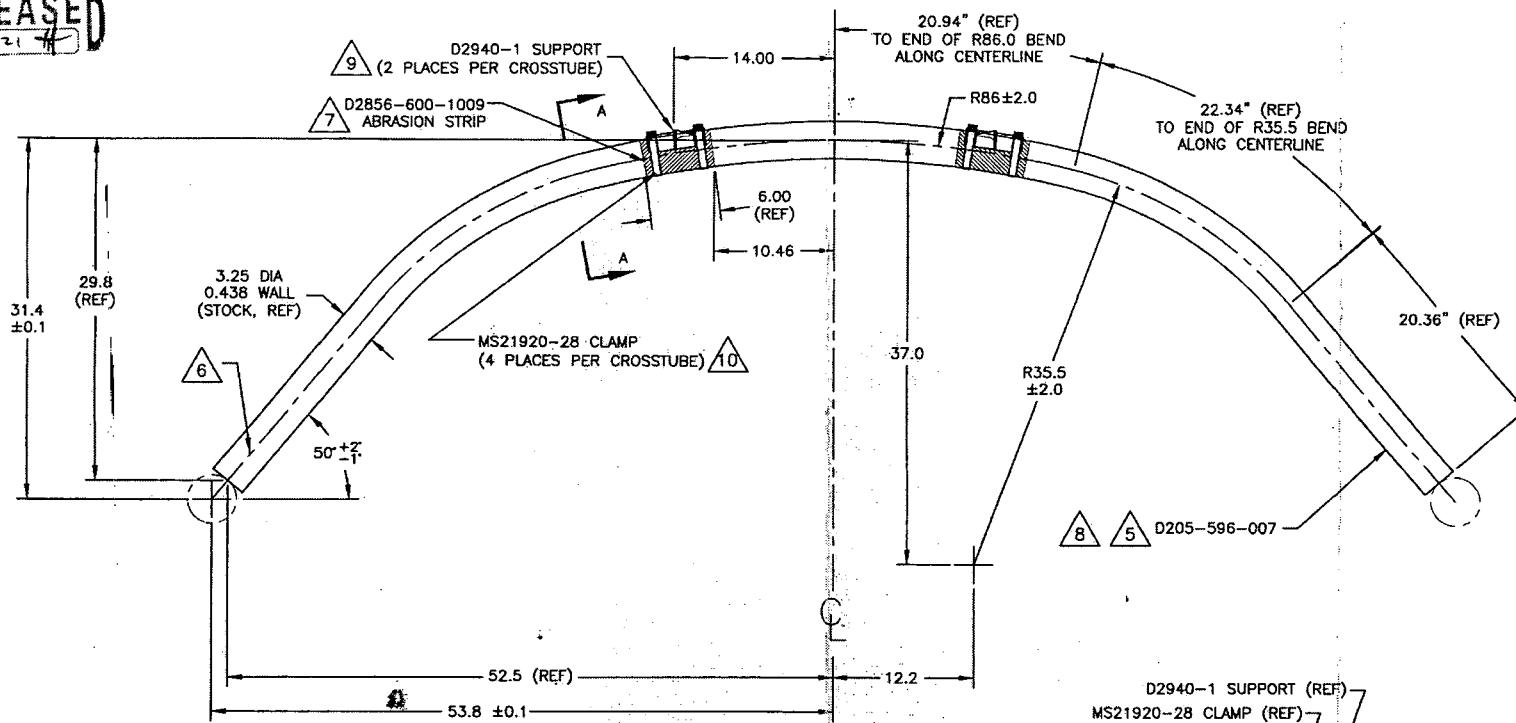
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

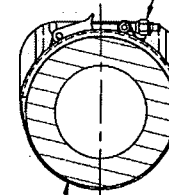
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
02.11.20



D2940-1 SUPPORT (REF)  
MS21920-28 CLAMP (REF)



SECTION A-A  
SCALE 2:5

D2856-600-1009 ABRASION STRIP (REF)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6008-180  
FINISHED LENGTH = 127.28
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB

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A	02.11.20	NEW ISSUE
DESIGN #	DRAWN BY #	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D205-596-107
DATE 02.11.20	TITLE CROSSTUBE AFT EXTENDED	REV. A SHEET 1 OF 1 SCALE 1:10

NO 2866-3  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

**Chris Provencal**

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** October 5, 2006 4:16 PM  
**To:** 'Chris Provencal'  
**Subject:** RE: ncr D205-596-107

THIS PART IS ACCEPTABLE.

DAVID

---

**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Thursday, October 05, 2006 11:50 AM  
**To:** David Shepherd (David Shepherd)  
**Subject:** ncr D205-596-107

David,

Qty(1) D205-596-107, they haven't cut the tube yet, they've marked in their cut lines.

The height is OK at 29.8"

The angles on either side are OK at 49 deg, 50deg.

The half spans are 52.56" and 52.25" (dwg says 52.5), so the second span is under by 0.25".

Is this part acceptable at these dims?

-Chris

--  
No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.407 / Virus Database: 268.12.13/463 - Release Date: 10/4/2006

--  
No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.407 / Virus Database: 268.12.13/463 - Release Date: 10/4/2006

05/10/2006



Date: Friday, 12/01/2007 3:03:24 PM  
User: Linda Lacelle

# **Process Sheet**

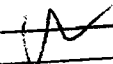
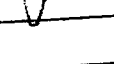
Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 30252  
Estimate Number : 10804  
P.O. Number : N/A  
This Issue : 12/01/2007  
Prsht Rev. : NC  
First Issue : N/A  
Previous Run : 30251

S.O. No. : N/A  
Type : OVERHEAD

Drawing Name : D205-594 - ECN 904

Part Number : Z\_CUSTOM  
Drawing Number : UPDATE PAPERWORK  
Project Number : N/A  
Drawing Revision : N/A  
Material : N/A  
Due Date : 19/01/2007

Qty: 1 Um: Each

Written By :   
Checked & Approved By :   
Comment :

## **Additional Product**

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK  
EASA STC EASA.IM.R.S.01198

D205-596-101 B 23804 1X 21  
D205-596-103  
D205-596-105 B 24946, B 24078, B 26841 = 3  
D205-596-107 B 28663 1 =  
D205-596-109

*08/01/15 27/01/15*

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/01/15*

Job Completion



*U 27-01-15*